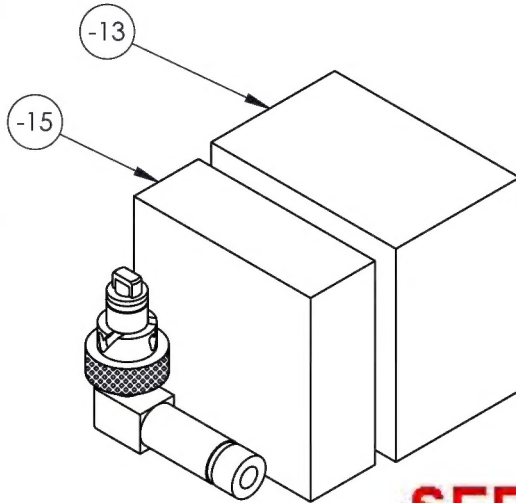
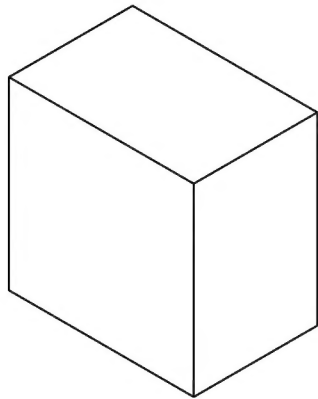


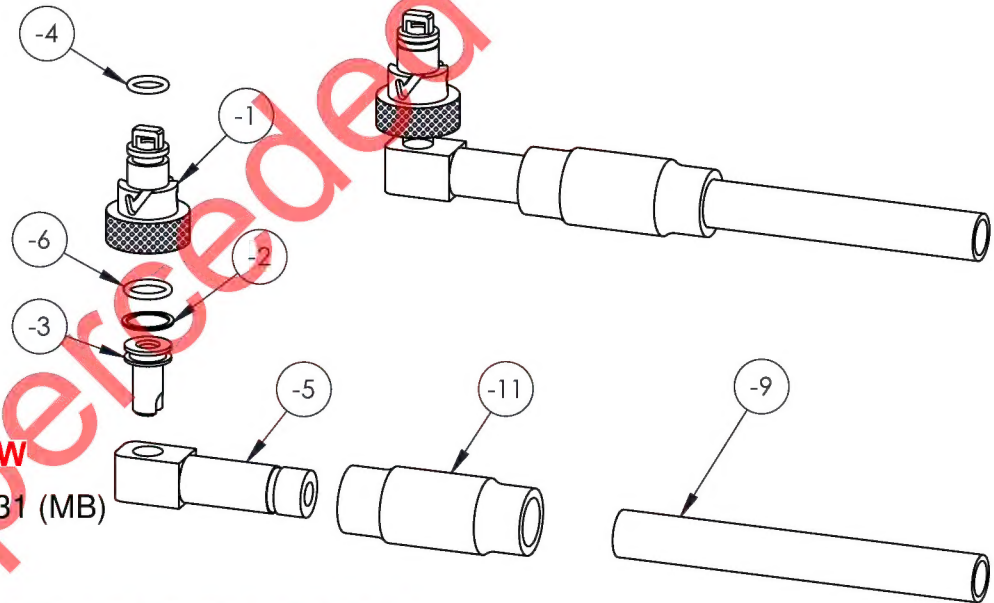
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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-7 ID REDUCED FROM .375 TO .370			
2	-5 HOUSING WAS 5/8 IN SQ , NOW 1/2 IN SQ			
3	NEW FORMAT, DELETED -7, -5 WAS 4 HOSE NOTCHES NOW 1. ADDED -8 HOSE CLAMP	5/12/2008	WP	RW
4	ADDED FREEWHEELIN ASSY. TO TITLE, CORRECTED MODELS USED ON. -1 EXTENDED TIP .027, PIN CENTER TO TIP WAS .623, NOW .650.	5/13/2010	WP	DW
4A	CORRECTED -1 DIMENSION FROM .623 TO .650 PER G.E.	8/12/2011	WP	RW
5	MODIFIED -5 TO WORK WITH COUPLING, ADDED COUPLING, CH'D -9 HOSE FROM Ø3/8 OD X Ø1/4. IMPROVED PRESS FIT DIMS ON -3 TO -5, ADDED -13, -15. EXPLODED VIEWS AND UPDATED BOM.	11/27/2012	JAG	SE
6	-4 CH'D O-RING SPEC WAS V75-012 IS V75-011. -5 CH'D HOLE WAS Ø.3131/.3125 ∇ .300 IS Ø.3131/.3125 ∇ .380. ADDED 1.790 LOCATION DIM.	2/12/2013	BIM	RW
7	-1 CH'D O.A.L. WAS 1.104 IS 1.229. ADDED MISSING DIM Ø4.300 +/- .002, CH'D DIMS WAS Ø.620 IS Ø.620 +/- .002, WAS 2X Ø.093 ∇ .093 IS 2X Ø.093 +.005/- .000 ∇ .093.	3/14/2013	BIM	GE
7A	-1 DELETED DIM .123. CH'D DIM WAS 2X Ø.093 +.005/- .000 ∇ .093 IS .093 +.005/- .000 ∇ .093, WAS .025 X 45° IS .03 X 45°. -15 CH'D MATERIAL TO NEW PIG CORP. #PAD210 & ADDED DIMS.	2/6/2014	DPD	RW

UNDER REVIEW
URF 19-545 19.01.31 (MB)

SEE ATTACHED DEVIATION



NOTES:
1. USED ON BELL 206A/B, B3, L, L1, L3 & 214B, ST.

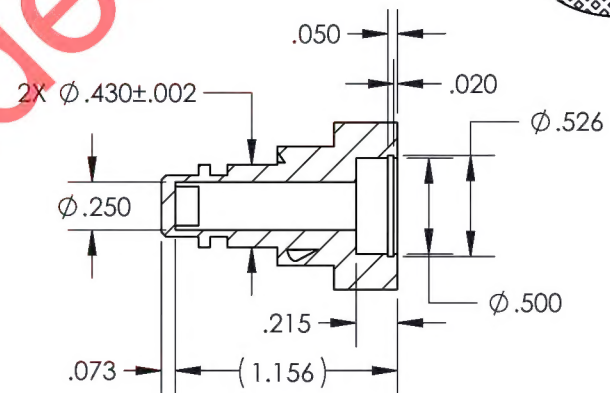
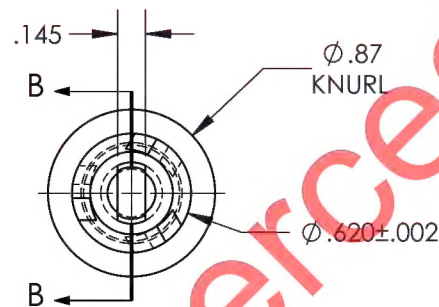
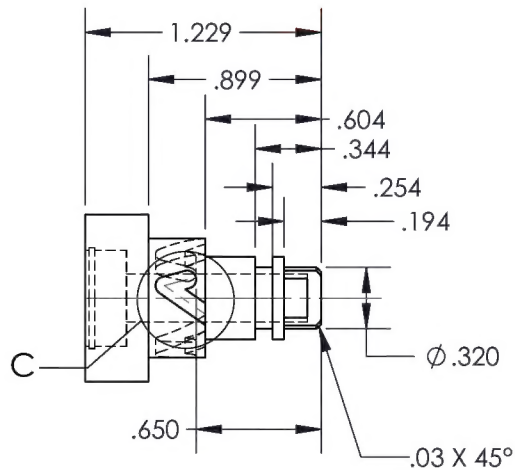
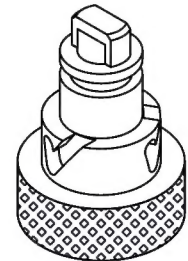
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	FITTING END	6061	Ø7/8 X 1-3/8	2
		B/O	-2	1	SPIRAL SNAP RING	STEEL	WH-50 SMALLEY or RR50 SPIRALOC	1
			-3	1	ROTATIONAL CONNECTOR	6061	Ø1/2 X 7/8	3
		B/O	-4	1	O-RING	VITON	V75-011	1
			-5	1	HOSE END	6061	1/2 X 1/2 X 2-1/4	4
		B/O	-6	1	O-RING	VITON	2-011	1
		B/O	-9	1	HOSE	VINYL	Ø1/2 O.D. x Ø3/8 I.D. x 6ft KURI-TECH #K010-0608	1
		B/O	-11	1	COUPLING	NICKEL-PLATED BRASS	Ø1/2 MCMASTER-CARR #51495K116	1
		B/O	-13	1	BOX	POLYPROPYLENE	DE LUZ CONTAINERS #FT-49	1
		B/O	-15	1	FOAM	POLYESTER/POLYURETHANE	1 X 2.6 X 2.6 NEW PIG CORP. #PAD210	1

RED BARN MACHINE	
TITLE T/R GEARBOX AND FREEWHEELING ASSEMBLY DRAIN TOOL	
DWG NO. RB DB3225L	REV 7A
MAT'L	DRAWN BY D. ROBERTS II
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED D Weil
.XXX ± .005	HEAT TREAT
.XX ± .01	FINISH
.X ± .1	SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	NOTE 1
SCALE 1:2	DATE 4/16/2002
	SHEET 1 OF 4

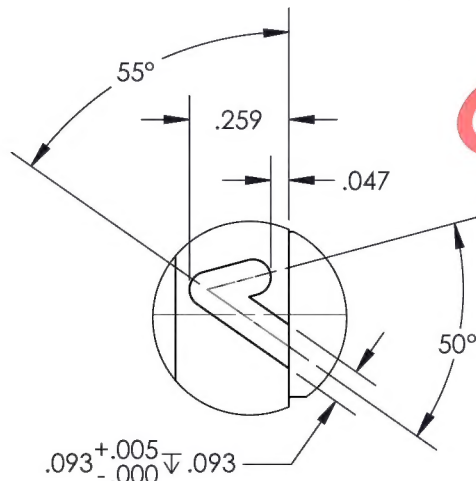
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SEE ATTACHED DEVIATION

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
4	EXTENDED TIP .027, PIN CENTER TO TIP WAS .623 TO .650	5/13/2010	WP	DW
4A	CORRECTED -1 DIMENSION FROM .623 TO .650 PER G.E.	8/12/2011	WP	RW
7	-1 CH'D O.A.L. WAS 1.104 IS 1.229. ADDED MISSING DIM $\phi 4.300 \pm .002$, CH'D DIMS WAS $\phi .620$ IS $\phi .620 \pm .002$, WAS $2X \phi .093 \nabla .093$ IS $2X \phi .093 \pm .005/- .000 \nabla .093$.	3/14/2013	BIM	GE
7A	-1 DELETED DIM .123, CH'D DIM WAS $2X \phi .093 \pm .005/- .000 \nabla .093$ IS $\phi .093 \pm .005/- .000 \nabla .093$, WAS $.025 X 45^\circ$ IS $.03 X 45^\circ$.	2/11/2014	DPD	RJC



SECTION B-B



DETAIL C
SCALE 2 : 1
3X EQUALLY SPACED

(1)
FITTING END

UNDER REVIEW

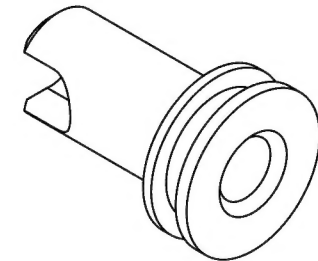
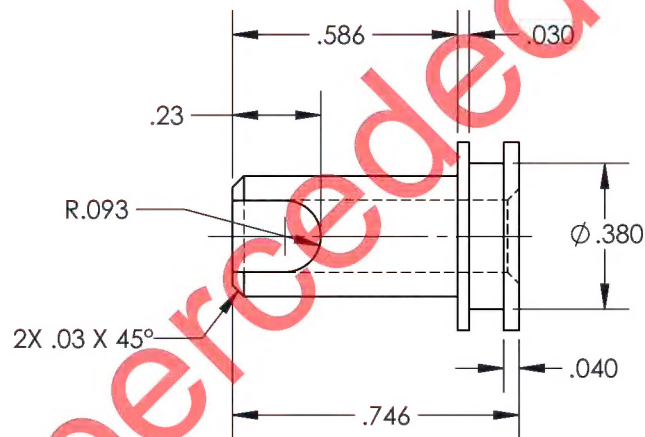
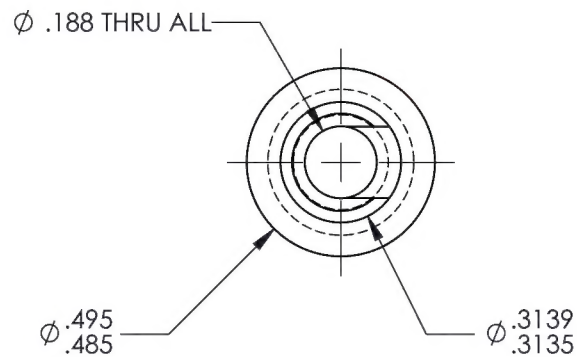
URF 19-545 19.01.31 (MB)

RED BARN MACHINE	
TITLE T/R GEARBOX AND FREEWHEELING ASSEMBLY DRAIN TOOL	
DWG NO. RB DB3225L-1	REV 7A
MAT'L 6061	DRAWN BY D ROBERTS II
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX ± .005 FRACTIONS ± 1/32	HEAT TREAT
.XX ± .01 ANGLES ± 5°	FINISH RED ANODIZE
.X ± .1	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	NOTE 1 SHT 1
SCALE 1:1	DATE 4/16/2002
SHEET 2 OF 4	

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
5	CH'D Ø.314 TO .3139 / .3135	11/27/2012	JAG	SE

SEE ATTACHED DEVIATION



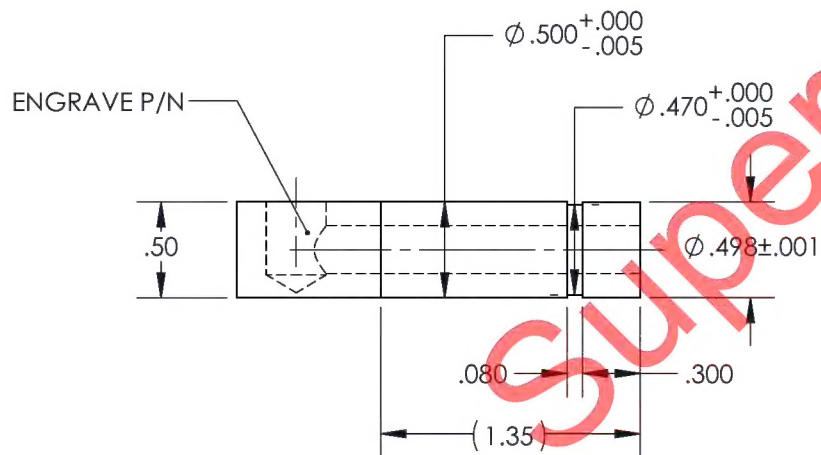
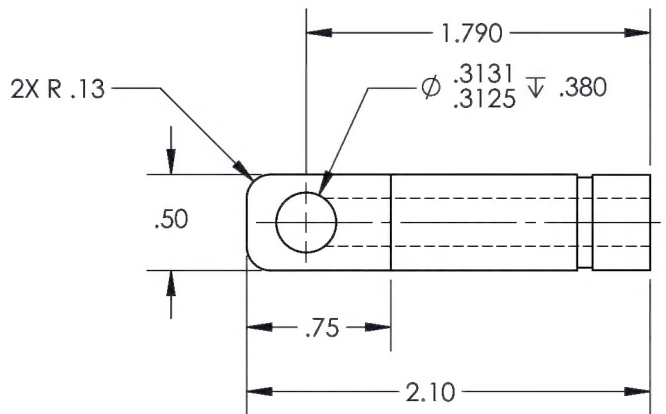
UNDER REVIEW

URF 19-545 19.01.31 (MB)

(-3)
ROTATIONAL CONNECTOR

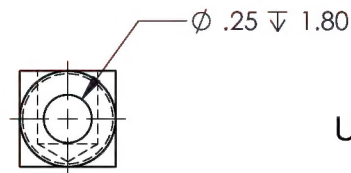
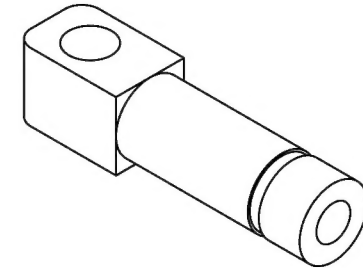
RED BARN MACHINE	
TITLE T/R GEARBOX AND FREEWHEELING ASSEMBLY DRAIN TOOL	
DWG NO. RB DB3225L-3	REV 7A
MAT'L 6061	DRAWN BY: D ROBERTS
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	APPROVED <i>D Weil</i>
.XXX $\pm .005$	HEAT TREAT
.XX $\pm .01$	FINISH RED ANODIZE
.X $\pm .1$	SPEC MIL-A-8625F, TYPE II, CLASS II
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	USED ON MODEL
2. DIMENSIONAL LIMITS APPLY AFTER PLATING	NOTE 1, SHT 1
SCALE 2:1	DATE 4/16/2002
SHEET 3 OF 4	

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(-5)
HOSE END

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
2	-5 HOUSING WAS 5/8 in SQ, NOW 1/2 in SQ			
3	-5 HOSE NOTCHES FROM FOUR TO 1.	5/12/2008	WP	RW
5	CH'D HOSE END TO USE WITH COUPLING	11/27/2012	JAG	SE
6	-5 CH'D HOLE WAS $\phi .3131 / .3125 \pm .300$ IS $\phi .3131 / .3125 \pm .380$. ADDED 1.790 LOCATION DIM.	2/12/2013	BIM	SE



UNDER REVIEW

URF 19-545 19.01.31 (MB)

SEE ATTACHED DEVIATION

RED BARN MACHINE			
TITLE T/R GEARBOX AND FREEWHEELING ASSEMBLY DRAIN TOOL			
DWG NO. RB DB3225L-5			REV 7A
MAT'L 6061		DRAWN BY: D ROBERTS	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		APPROVED <i>D Weil</i>	
.XXX ± .005		HEAT TREAT	
.XX ± .01		FINISH RED ANODIZE	
.X ± .1		SPEC MIL-A-8625F, TYPE II, CLASS II	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R		USED ON MODEL	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING		NOTE 1 SHT 1	
SCALE 1:1	DATE 4/16/2002	SHEET 4 OF 4	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RB DB3225L Rev. 7A</u>		DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>		DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>				
Date : _____		Sequence # : _____		QTY Affected : _____		MRB (QSI042) Oct 30, 2018		
Description Work Order Deviation				Disposition				
Kuri-Tech Hose (K010-0608) easily pulls out of Coupling (McMaster Carr 51495K116)				Install a 1.0" long, 0.38" OD, 0.25" ID piece of Stainless Steel into one end of the Kuri-Tech Hose until flush. Attach the modified end of the Kuri-Tech Hose to the Coupling before placing tool into packaging (if applicable). This deviation is acceptable. The fit, form and function of the part will be as originally intended.				Completed By
								Lead hand / Supervisor
								QC / QA Coordinator
Root Cause				FAULT CATEGORY				
<div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input checked="" type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>				<div style="display: flex; flex-direction: column;"> <div>Pressure/Forced <input type="checkbox"/></div> <div>Bending <input type="checkbox"/></div> <div>Crushing <input type="checkbox"/></div> <div>Cracks <input type="checkbox"/></div> <div>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/></div> <div>Marks/Chatter <input type="checkbox"/></div> <div>Mislabeled <input type="checkbox"/></div> <div>Contamination <input type="checkbox"/></div> <div>Misaligned/off center <input type="checkbox"/></div> <div>BOM/Route <input type="checkbox"/></div> <div>Broken/Damage/Defect <input type="checkbox"/></div> <div>Incomplete/Unclear Instructions <input type="checkbox"/></div> <div>Drill Holes <input type="checkbox"/></div> <div>Fit/Function <input type="checkbox"/></div> <div>Power Loss/Surge <input type="checkbox"/></div> <div>Folio/Program <input type="checkbox"/></div> <div>Grain Direction <input type="checkbox"/></div> <div>Weld <input type="checkbox"/></div> <div>Wrong Stock Pulled <input type="checkbox"/></div> <div>Out of Sequence <input type="checkbox"/></div> <div>Off-set/Set-up <input type="checkbox"/></div> <div>Positioned Wrong <input type="checkbox"/></div> <div>Outside Tolerance <input type="checkbox"/></div> <div>Drawing <input type="checkbox"/></div> <div>Finish <input type="checkbox"/></div> <div>Part Lost/Missing <input type="checkbox"/></div> <div>Misread <input type="checkbox"/></div> </div>				
Other/Details:								